












DATE: Tuesday, 11/29/2005 12:43:44 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SPACER BLOCK
Job Number	: 25004A		
Estimate Number	: 10251		
P.O. Number	: N/A	Part Number	: D3193041
This Issue	: 11/29/2005	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D3193 REV <i>B C</i> <i>06-09-22</i>
First Issue	: N/A	Project Number	: N/A
Previous Run	: 24048A	Drawing Revision	: B
	Type : LANDING GEAR	Material	: N/A
Written By	: <i>[Signature]</i>	Due Date	: 1/10/2006
Checked & Approved By	: <i>[Signature]</i>	Qty:	8
Comment	: Est Rev:A New Issue 05-11-05 JLM	Um:	Each
Additional Product			
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6B2500X03500	6061-T6 Bar 2.5" x 3.5"	
			
Comment: Qty.: 0.5156 f(s)/Unit <i>06-09-22</i> Total: 4.1244 f(s) Material: 6061-T6/T651 (QQ-A-225/8 or QQ-A-200/8) (M6061T6B2.500x03.500) Identify for D3193-1 <i>1.56</i> Batch: <i>1118325, M19805</i> <i>2004</i> <i>SA 05-12-21</i>			
2.0	BAND SAW	BAND SAW	
			
Comment: BAND SAW Cut blanks: 3.500" x 2.500" x 5.900" long Bar <i>SA 05-12-21</i>			
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
			
Comment: HAAS CNC VERTICAL MACHINING #1 1-Machine as per Folio FA374 and Dwg D3193 Identify as D3193-1 <i>3/1/08</i> 2-Deburr and Tumble <i>second check</i> <i>5-G 06109125 ml</i> <i>06/09/22</i> <i>8</i>			
4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	
			
Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 <i>Q.M. 06-09-26</i> <i>(8)</i>			
5.0	POWDER COATING	POWDER COATING	
			
Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3 <i>Q.M. 06-10-02</i> <i>(8)</i>			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ ☐ Date: 06/10/10
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 11/29/2005 12:43:44 PM
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Seq. #: Machine Or Operation: Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

PU 4/10/03 (8)

7.0

MS20426AD377

Rivet



Comment: Qty.: ~~16.0000~~ Each(s)/Unit Total : 128.0000 Each(s)

Pick: 8.0

Qty Part Number

Description Batch

MS20426AD377

Rivet ~~174533~~

8.0

M17694

X

8.0

MS21073L4

NUTPLATE



Comment: Qty.: ~~8.0000~~ Each(s)/Unit Total : 64.0000 Each(s)

Pick: 4.0

Qty Part Number

Description Batch

4.0

MS21073L4

Nut Plate

M18728

PU 4/10/03 (8)

9.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble D3193-041 as per Dwg D3193

SB 06/10/05 8

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

26.10.05

11.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/10/10

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

N/A
u
PRO

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06/01/06	12	permanent change kit added on D206-667011		06/01/06		Le	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: SPACER BLOCK

Job Number: 25004A

Part Number: D3193041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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13.0	AN46A	Bolt
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Comment: Qty.: 8.0000 Each(s)/Unit Total : 64.0000 Each(s)

Pick: Packing Kit

Qty	Part Number	Description	Batch
8	AN4-6A	Bolt	

14.0	AN47A	Bolt
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Comment: Qty.: 8.0000 Each(s)/Unit Total : 64.0000 Each(s)

Pick: Packing Kit

Qty	Part Number	Description	Batch
8	AN4-7A	Bolt	

15.0	AN960JD416	Washer
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Comment: Qty.: 16.0000 Each(s)/Unit Total : 128.0000 Each(s)

Pick: Packing Kit

Qty	Part Number	Description	Batch
16	AN960JD416	Washer	

16.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
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Comment: INSPECT 100% KITS FOR COMPLETENESS

17.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-667-011

Job Completion



u 26-10-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 25004 A
Description: SPACER BLOCK		Part Number: D3193-1
Inspection Dwg: D3193 , Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.435	± 0.016	3.436	✓			
2.012	± 0.010	2.013	✓			
1.200	± 0.010	1.200	✓			
2.006	± 0.010	2.003	✓			
R0.125	± 0.010	R0.120	✓			
5.878	± 0.016	5.879	✓			
4.878	± 0.005	4.880	✓			
2.550	± 0.005	2.548	✓			
2.435	± 0.005	2.434	✓			
Ø0.098	± 0.004 -0.001	Ø0.099	✓			
Ø0.180X108	± 0.010	Ø0.182X108	✓			
Ø0.266	± 0.006 -0.001	Ø0.271	✓			
0.260	± 0.010	0.257	✓			
2.812	± 0.010	2.812	✓			
0.255	± 0.010	0.254	✓			
0.850	± 0.010	0.846	✓			

Measured by: <i>gml</i>	Audited by: <i>En</i>	Prototype Approval:
Date: 06/09/22	Date: 06/09/22	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

5.0 PARTS LIST

Item	Qty -011	Qty -013	Qty -015	Qty -101	Qty -201	Qty -103	Qty -203	Qty -105	Qty -205	Part Number	Description
	X									D206-667-011	SPACER BLOCK KIT
		X								D206-667-013	NUT PLATE KIT (-101/-103/-105/-203/-205)
			X							D206-667-015	NUT PLATE KIT (-201)
				X						D206-667-101	CROSSTUBE INSTALLATION, 206A/B HIGH FWD
					X					D206-667-201	CROSSTUBE INSTALLATION, 206A/B HIGH AFT
						X				D206-667-103	CROSSTUBE INSTALLATION, 206L/L-1/L-3/L-4 HIGH FWD
							X			D206-667-203	CROSSTUBE INSTALLATION, 206L/L-1/L-3/L-4 HIGH AFT
								X		D407-667-105	CROSSTUBE INSTALLATION, 407 HIGH FWD
									X	D407-667-205	CROSSTUBE INSTALLATION, 407 HIGH AFT
1				1						D206-667-141	CROSSTUBE ASSEMBLY, 206A/B HIGH FWD
2					1					D206-667-241	CROSSTUBE ASSEMBLY, 206A/B HIGH AFT
3						1				D206-667-143	CROSSTUBE ASSEMBLY, 206L/L-1/L-3/L-4 HIGH FWD
4							1			D206-667-243	CROSSTUBE ASSEMBLY, 206L/L-1/L-3/L-4 HIGH AFT
5								1		D407-667-145	CROSSTUBE ASSEMBLY, 407 HIGH FWD
6									1	D407-667-245	CROSSTUBE ASSEMBLY, 407 HIGH AFT
10				*2	*2	*2		*2		D2891-1	SUPPORT
11							*2			D2892-1	SUPPORT
12									*1	D2894-1	SUPPORT
13				*2	*2	*2		*2		D2856-400-694	ABRASION STRIP
14							*2		*2	D2856-400-773	ABRASION STRIP
15									*1	D2856-600-851	ABRASION STRIP
16				*4	*4	*4		*4		MS21920-20	CLAMP
17							*4		*4	MS21920-22	CLAMP
18									*2	MS21920-24	CLAMP
19				4	4	4		4		AN5-32A	BOLT
20							4		4	AN5-34A	BOLT
21				4	4	4	4	4	4	MS21042L5	NUT (OR MS21042-5)
22				8	8	8	8	8	8	AN960JD516	WASHER
23									*2	D3190-1	CHAFING SHIELD
30	8									AN4-6A	BOLT
31	8									AN4-7A	BOLT
32	16									AN960JD416	WASHER
33	2									D3193-041	SPACER BLOCK ASSEMBLY
40		2		*2		*2	*2	*2	*2	D2873-043	NUT PLATE
41		2		*2		*2	*2	*2	*2	D2873-045	NUT PLATE
42			2		2					D2872-043	NUT PLATE
43			2		2					D2872-045	NUT PLATE
44		10		10		10				AN5-7A	BOLT
45		10	10		10		10	10	10	AN5-10A	BOLT
46		4	4	4	10	4		4		AN5-30A	BOLT
47		4					4		4	AN5-32A	BOLT
48		18	18	10	12	10	10	10	10	AN960JD516	WASHER
49		4	4		6					MS21042L5	NUT (OR MS21042-5)

*REFERENCE ONLY. PARTS ARE INCLUDED IN D206-667-141/241/143/243, & D407-667-145/245 ASSEMBLIES ABOVE

REFERENCE ONLY

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Revision: C

Date: 05.07.26